

Work Order ID 126401-2

Thursday, November 06, 2014 10:51:57 AM

647.4313

126401

Page 1

Item ID: 647.4313

Revision ID:

Item Name: RH Upper Strut

Start Date: 11/6/2014 Start Qty: 16.00

Required Date: 11/6/2014 Req'd Qty: 16.00

Reference:

REV - Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: MLS

Date: 11-11-06

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

647.4300

A

110

0.00

110

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut 647.4312 plate 3.928X1.985 as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

(20)

11/11/06

(20)

11/11/06

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Page 2

Item ID: 647.4313 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: RH Upper Strut
 Start Date: 11/6/2014 Start Qty: 16.00 *16* Cust Item ID:
 Required Date: 11/6/2014 Req'd Qty: 16.00 *16* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				20			DAS 38 9-89
130									
QC	Memo	0.00							
Quality Control									
140		0.00							
140						20	14-11-07		MAL/R
Small Fab	Memo	0.00							
Small Fab	1- Fabricate tube as per dwg by cutting (22.00") one end 27.7 degree and other end punch, bend and drill hole as per dwg								
150	QC5- Inspect part completeness to step on W/O	0.00							
150						20	NOV 07 2014		DAS 24 9-89
QC	Memo	0.00							
Quality Control									

NOV 07 2014

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Item ID: 647.4313 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: RH Upper Strut
 Start Date: 11/6/2014 Start Qty: 16.00 *16* Cust Item ID:
 Required Date: 11/6/2014 Req'd Qty: 16.00 *16* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab Large Fab	Weld per dwg A/R S.S. rod Batch: <u>M125054</u> Memo Weld tube to plate as per dwg. Weld end were tube is punch.	0.00 0.00				<u>20</u>	<u>EL</u>	<u>14-11-10</u>	<u>DAS</u> <u>24</u> <u>9-89</u>
170 *170* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				<u>20</u>		<u>NOV 10 2014</u>	<u>DAS</u> <u>24</u> <u>9-89</u>
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>(20)</u>		<u>14-11-10</u>	<u>EB</u>

Work Order ID 126401

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126401

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Item ID: 647.4313 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: RH Upper Strut
 Start Date: 11/6/2014 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 11/6/2014 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190		0.00							
190						14			CR 11.11.14
SprayPaint	Memo	0.00							
Spray Painting	Prime as per dwg (see note 4)								
	Batch: 127082								
200	QC14- Inspect Spray Paint	0.00							DAS
200									33
QC	Memo	0.00							9-89
Quality Control									NOV 16 2014
210		0.00							
210						14			5/11/14
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***								

Work Order ID 126401***126401***

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Item ID: 647.4313

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: RH Upper Strut

Stop

NS2

Start Date: 11/6/2014 Start Qty: 16.00

16

Cust Item ID:

Required Date: 11/6/2014 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21 - Final Inspection - Work Order Release

0.00


220

QC

Memo

0.00

Quality Control

14/11/18 MF
14-11-18

Picklist Print

Thursday, November 06, 2014 10:52:00 AM

Page 1

Work Order ID: 126401

126401

Parent Item: 647.4313

647 4313

Parent Item Name: RH Upper Strut

Start Date: 11/6/2014

Required Date: 11/6/2014

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A 12.10.26 NEW ISSUE DD VERF:JLM IPP
REV:B 14.11.06 CHG MATERIAL TO S.S. DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

sf

473.5356

1

M304S16GA

**

304/316 Sheet .063

Dec 14/11/06

Location

Loc Qty

Loc Code

MAT020

360.1356

M127821

71.317

M129449

192.8186

M130745

96

TPI

113.4

M129545

113.4

M304TR0.500W.049

Purchased

No

f

189.3515

31

M304TR0 500W 049

**

304 RD Tube .500 x .049W

1471-10

Location

Loc Qty

Loc Code

MAT017

189.3515

M127937

168.548

M128833

20.8035

x 35.833'

35.833' 36'

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 04048

SHEET 1 OF 1

DWG NO. 647.4300

REV: N/C

PREPARED
BY

D. PETERS

DATE: 08/12/13

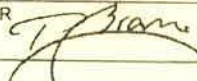
EFFECT ON DWG

☒ INC. ☐ UNINC.

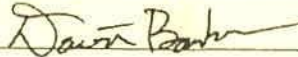
DWG TITLE: STRUT

APPROVED BY:

ENGR



MFG



QC



EFF

NEXT ORDER

TRANSACTION CODES (TC)

A-ADD C-CREATE

R-REVISE D-DELETE

REASON: MARKED INSPECTION DIMENSIONS

ECR

NONE

126401 MWS
14-11-06

DOCUMENTS EFFECTED:

☐ RFMS ☐ MDL ☐ INSTALL INSTRU

☐ ICA ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

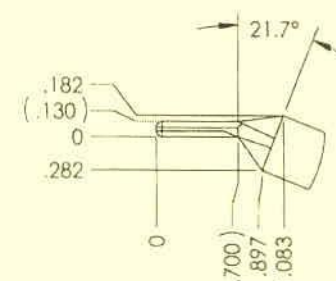
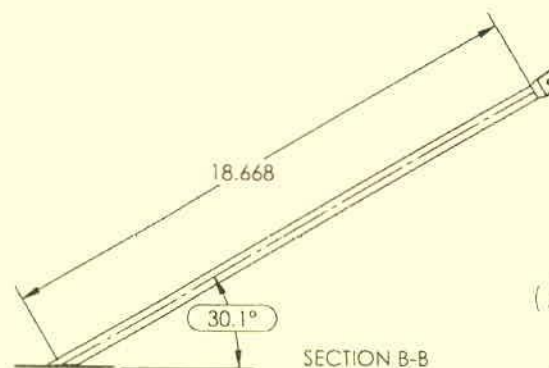
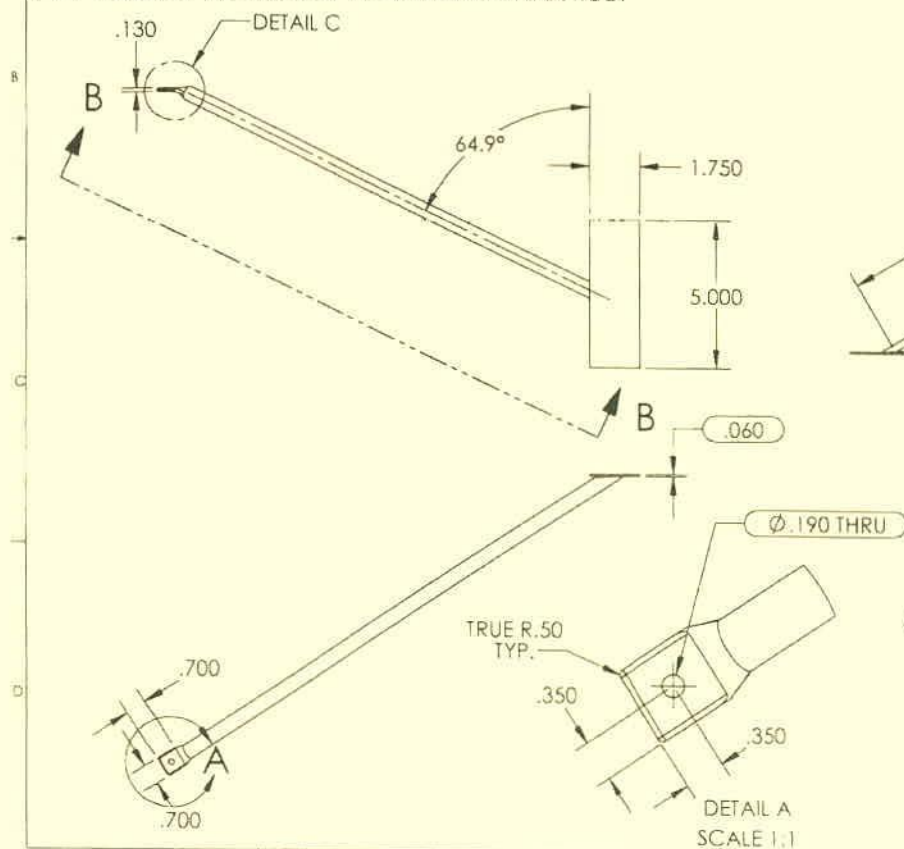
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NOTES: UNLESS OTHERWISE SPECIFIED

1. MATERIAL: 4130 STEEL PER AMS-S-18729, .06" THK.
2. MATERIAL: 4130 STEEL PER AMS-S-18729, .13" THK.
3. MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .049" WALL THK.
4. FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
7. WELD IAW MIL-STD-2219, TIG WELD WITH FILLER ROD.

REVISION			
REV	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION PER		
2	FINAL RELEASE	10/07/08	P. BRAYO
3	INCORPORATED ECH 04048	08/12/13	F. BRAYO

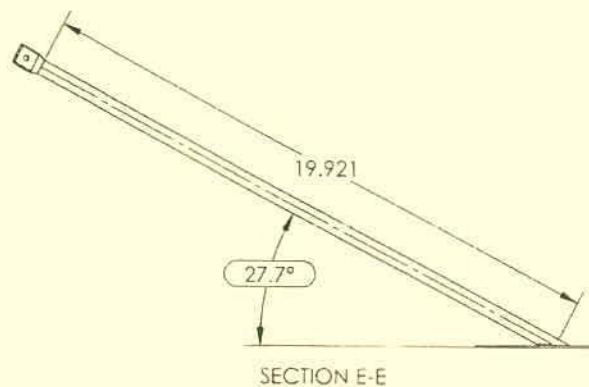
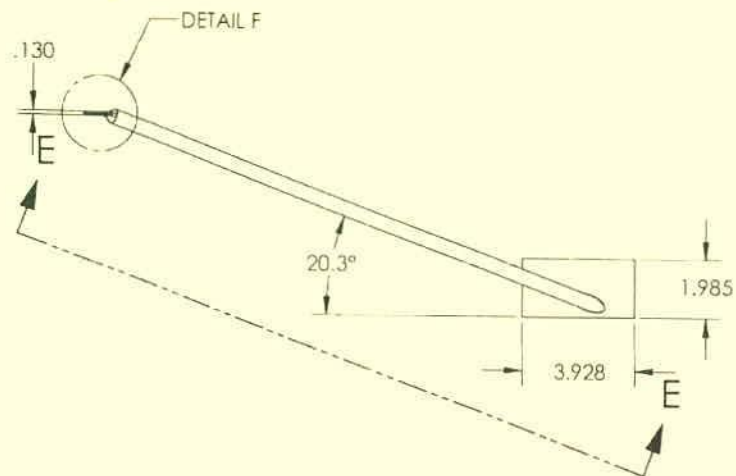
647.4310 SHOWN
647.4311 OPPOSITE



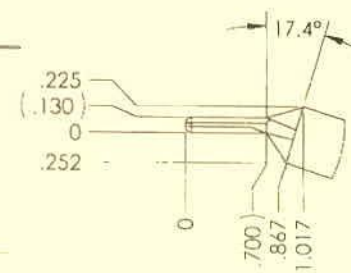
DETAIL C
SCALE 1:1
SHOWN NORMAL TO SIDE OF TAB

PARTS LIST			
QTY	DESCRIPTION	AMT.	SPEC
1	647.4313 RH UPPER STRUT	△△△△	△△△△
1	647.4312 LH UPPER STRUT	△△△△	△△△△
1	647.4311 RH LOWER STRUT	△△△△	△△△△
1	647.4310 LH LOWER STRUT	△△△△	△△△△
APICAL INDUSTRIES			
2608 TEMPLE HEIGHTS DR.			
OCEANSIDE, CA 92056-3517 (760) 724-5300			
STRUT			
REV	DATE	QTY	REV
B	07/12/13	647.4300	A
SCALE: NONE			
SHEET 1 OF 2			

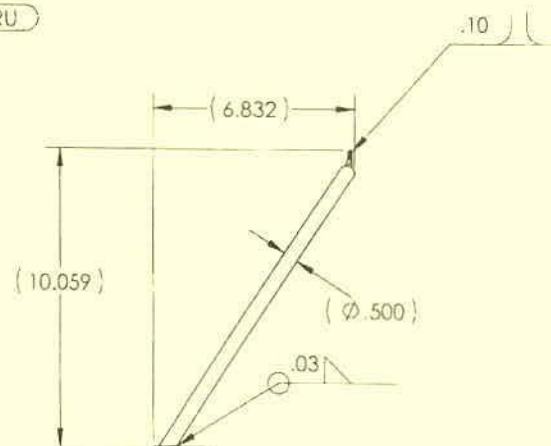
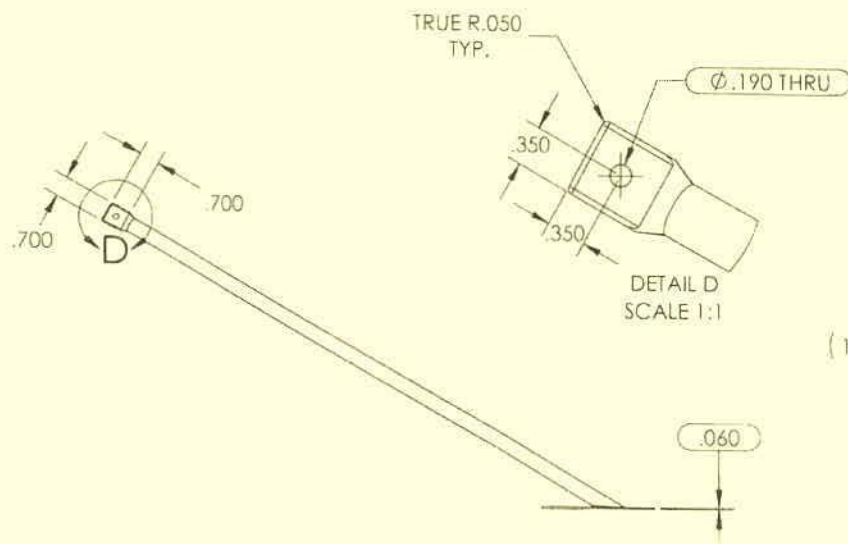
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647.4312 SHOWN
647.4313 OPPOSITE



DETAIL F
SCALE 1:1
SHOWN NORMAL TO SIDE OF TAB



GROUP / DATE MODEL / REV DRAWN / DESIGNED CHECKED / APPROVED BY / DATE		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92055-3512 (760) 724-5300	
PROJECT / PART 647.4300 / STRUT		SCALE: NONE	
SHEET / TOTAL 1 / 2		SHEET 1 OF 2	